

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008492**Date Inspected:** 16-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Shen Fu You, Mr. Xhen Xi, Mr. Chen Xi

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**OBG Bay 1**

This QA Inspector observed ZPMC welder Mr. Li Ming Qian stencil 054460, using flux cored welding procedure WPS-B-T-2132-2 to make OBG cross beam weld CB201G-014-148. This QA Inspector observed ZPMC CWI/QC Inspector Mr. Chen Xi has recorded a welding current of 298 amps and 30.2 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 216575, using flux cored welding procedure WPS-B-T-2132-2 to make OBG cross beam weld CB201G-014-148. This QA Inspector observed ZPMC CWI/QC Inspector Mr. Chen Xi has recorded a welding current of 300 amps and 30.1 volts. Items observed on this date appeared to generally comply with applicable contract documents.

**OBG Bay 2**

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welder Ms. Zhang Caimei, stencil 207237 is using welding procedure specification WPS-B-T-2211-B-L2C-S-2 to make floor beam submerged arc groove weld FB3084-001-023. This QA Inspector observed a welding current of approximately 570 amps and 30.0 volts. This QA Inspector observed Ms. Zhang Caimei is certified to make this weld and ZPMC QC Inspector Mr. Xhan Hai Feng is monitoring this welding. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Zu Zichuan stencil 205098, is using welding procedure WPS-B-P-2112 to make OBG floor beam shielded metal arc tack weld FB3059A-001-005. This QA Inspector observed a welding current of 170 amps and Mr. Zu Zichuan is qualified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is warm to the touch. Items observed on this date appeared to generally comply with applicable contract documents.

### OBG Bay 6

This QA Inspector observed ZPMC welder Mr. Liu Ji, stencil 070007 is using shielded metal arc process WPS-345-SMAW-2G(2F) Repair to perform weld repairs on stiffener to base plate weld SP2023-001-082. It appears these repairs were required as a result of areas that had been ground following ZPMC magnetic particle rejections of stiffener to baseplate welds. This QA Inspector observed a welding current of approximately 170 amps and Mr. Liu Ji is qualified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is warm to the touch. Items observed on this date appeared to generally comply with applicable contract documents.

### OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Lv Fenbao, stencil 045175 is using flux cored welding procedure WPS-B-T-2132 to make corner assembly weld CSD6-PP84-004. This QA Inspector measured a welding current of approximately 250 amps and 30.4 volts. This QA Inspector observed Mr. Lv Fenbao is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Ye Shen Jun, stencil 203871 is using flux cored welding procedure WPS-B-T-2132 to make corner assembly weld CSD6-PP84-004. This QA Inspector observed ZPMC QC has recorded a welding current of 287 amps and 30.1 volts. This QA Inspector observed Mr. Ye Shen Jun is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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